



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW0805G00332-3G-PO
Job Sheet 191266



Part No: RBW0805G00332-3G-PO **Job Qty:** 3 pcs

Part Name: Jacking Bracket, Helicopter Weighing



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/25/19

Job Tracking No:

Due Date: 4/29/19

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBW0805G00332-3G Rev.2 IPP Rev. A 19.02.25 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Sign-off
100	Purchasing	3 pcs	4/29/19	4/29/19	0.00	0.00	Purchasing - 1 Purchasing - 2 Purchasing - 3	MAR 27 2019
110	Packaging 2-1 - Receive - B4B	3 pcs	4/29/19	4/29/19	0.00	0.00	Packaging 2 - 1 - B4B Packaging 2 - 2 - B4B Packaging 2 - 3 - B4B Packaging 2 - 5 - B4B Packaging 2 - 4 - B4B Packaging 2 - 6 - B4B Packaging 2 - 7 - B4B Packaging 2 - 8 - B4B Packaging 2 - 9 - B4B Packaging 2 - 10 - B4B Packaging 2 - 11 - B4B Packaging 2 - 12 - B4B Packaging 2 - 13 - B4B Packaging 2 - 14 - B4B Packaging 2 - 15 - B4B Packaging 2 - 16 - B4B	MAR 27 2019
120	QC 6	3 pcs	4/29/19	4/29/19	0.00	0.00	QC 6 - 42 QC 6 - 9 QC 6 - 68 QC 6 - 61	MAR 28 2019 68 9-89
130	Small Fab - 2 - B4B	3 pcs	4/29/19	4/29/19	0.00	0.30	Small Fab - 1 - B4B Small Fab - 2 - B4B Small Fab - 3 - B4B Small Fab - 4 - B4B Small Fab - 5 - B4B Small Fab - 6 - B4B Small Fab - 7 - B4B	MLC
135	External Load - 2 - B4B	3 pcs	4/29/19	4/29/19	0.00	0.75	External Load - 1 - B4B	AP 2019/05/02

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Container No: S166620



Part: RBW0805G00332-3G

Job No: 191266

Serial No/Batch: S166620

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 03/27/19

Plex 2/25/19 3:12 PM dart.Lussier.Patrick

140 QC 5	3 pcs	4/29/19	0.00 0.00	External Load - 2 - B4B	
				External Load - 3 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 42	DAS
				QC 5 - 43	19
				QC 5 - 49	9-83
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
150 Packaging 3-1 - Stock - B4B	3 pcs	4/29/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
160 QC 21 - FG	3 pcs	4/29/19	0.00 0.00	QC 21 - FG - 21	DAS
				QC 21 - FG - 70	21
				QC 21 - SA - 53	9-83

Part Op 100 - Issue P/O: _____ MANUFACTURE RBW0805G00332-3G AS PER DWG Supplier: ARROW TECH MACHINE
 Descriptions: WORKS -Certificate of conformity is required
 130 - 1- Engrave T/N and/or P/N on RB 41011 placard using MARKTRONIC engraver as per DWG. 2-Install placard using #2 drive screws
 135 - Load test as per drawing sheet 5.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW0805G00332-3Gp	Jacking Bracket, Helicopter Weighing	3 pcs (1 ea)	100-Purchasing	
90081A077	Drive Screw #2 1/4" Long	12 Ea (4 ea)	130-Small Fab - 2 - B4B	6X504890 0X5148 008
RB41011	Dart Tooling Placard, Aluminum	3 Ea (1 ea)	130-Small Fab - 2 - B4B	5021040

Job Allocations

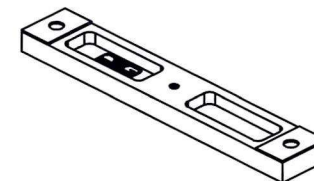
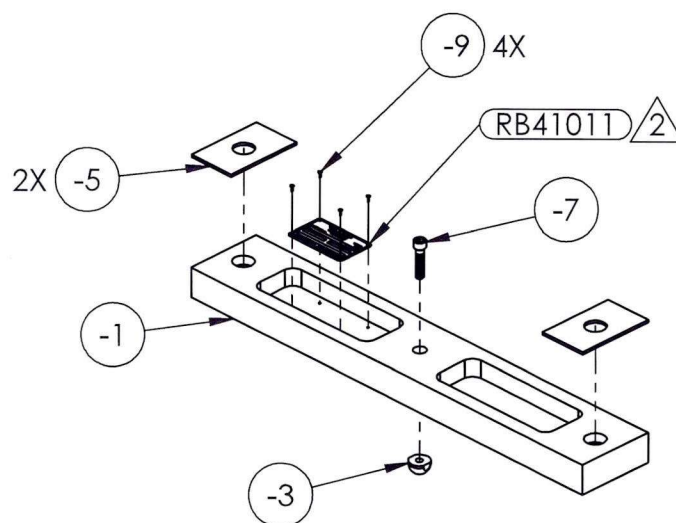
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW0805G00332-3Gp	3	0	0
130-Small Fab - 2 - B4B	90081A077	12	106	0
	RB41011	3	403	0

Part Specifications

Specifications could not be found.

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		-5 ADDED Ø1.00.	1/23/2012	JAG	
B		-1 CH'D DIM WAS 1.50 IS (1.50). -3 CH'D DIM WAS Ø.33 ∇ .45 3/8-24 UNF ∇ .40 IS Ø.33 ∇ .45 MAX 3/8-24 UNF ∇ .40 MAX. -5 CH'D DIM WAS .13 IS (.13).	4/15/2014	DPD	RJC
2	16-0285	UPDATED TO NEW DRAFTING STANDARD. ADDED NOTE $\triangle$ SHEET 1. ADDED -9 AND RB41011. -1 ADDED DIMS 2X 2.02, 2X 2.95, 2X .85, 2X 1.70, 4X Ø.086 ∇ .32. DELETED ENGRAVE NOTE. CH'D FINISH WAS POWDER COAT SAFETY YELLOW IS POWDER COAT YELLOW SPEC FED #13538. -3 CH'D DIM WAS 1.5/16" IS .938/906. ADDED WEIGHT TEST SHEET TO DWG.	2/24/2017	RJC	SM



NOTE:

1. REF. OEM T/N: 3G0805G00332.

$\triangle$ 2 ENGRAVE T/N, S/N, "MADE IN USA".

DART AEROSPACE	
TITLE JACKING BRACKET, HELICOPTER WEIGHING	
DWG NO. RBW0805G00332-3G	REV 2
MAT'L HEAT TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX $\pm$.005 FRACTIONS $\pm$ 1/8 .XX $\pm$.01 ANGLES $\pm$ 5° .X $\pm$.1 SURFACES = 125/	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: GILBERT CHECKED: DUERFELDT OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: MACKOVJAK	
USED ON MODEL AGUSTA AW139	
SCALE 1:8	DATE 2/9/2011
SHEET 1 OF 6	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	JACKING BAR	1018/1020		2
			-3	1	CAP	303 S.S.		3
			-5	2	PAD	RUBBER	1/8 X 2-7/16 X 4 W/ADHESIVE (GASKET SPECIALTIES)	4
		B/O	-7	1	SOCKET HEAD CAP SCREW	S.S.	3/8-24 X 1-1/2 (MCMaster-CARR #92196A363)	1
		B/O	-9	4	#2 DRIVE SCREW	STEEL	#2 X 1/4 (MCMaster-CARR #90081A077)	1
		B/O		1	PLACARD	ALUMINUM	RB41011	1



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K6A 1K7
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Tel (613) 632-5200

PURCHASE ORDER

PO042715



Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

Ship To:

PO No: PO042715
PO Date: 2/26/19
Due Date: 4/29/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Lussier, Patrick
Phone:
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	191266	RBW0805G00332-3Gp			Jacking Bracket, Helicopter Weighing REV 2	Firmed	-	4/29/19	3 pcs	0 pcs	3 pcs	\$788.75/pcs	\$2,366.25
2		RBW6005G01431-3Gp			Dial Indicator Main Rotor Damper Support REV 1A	Firmed	-	4/29/19	2 pcs	0 pcs	2 pcs	\$1,050.00/pcs	\$2,100.00
3	191286	RBW6005G01831-3Gp			Dial Indicator Tail Rotor Support REV 3	Firmed	-	4/29/19	3 pcs	0 pcs	3 pcs	\$1,141.25/pcs	\$3,423.75
4	191287	RBW6205G00432-3Gp			Main Rotor Pitch Control Link Adjustment Tool REV 5	Firmed	-	4/29/19	3 pcs	0 pcs	3 pcs	\$2,030.50/pcs	\$6,091.50
Grand Total:													\$13,981.50



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PURCHASE ORDER

PO042715



Order Notes

Procurement Quality Clauses

A005 RIGHT OF ENTRY
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Three handwritten signatures are visible on the right side of the order notes section. The top signature is circled, and the bottom two are stacked vertically.

Plex 2/26/19 11:48 AM dart.Lussier.Patrick



**PHGE Machineworks dba
Arrowtech Machineworks**
29751 E Enid Rd. Unit C
Eugene, Oregon 97402
Phone: (541) 780-6938
Fax: (458) 215-4938

Packing Slip

NO. 481

Date: 3/22/2019 ✓
PO Ref: 042715 ✓
Ship via: Fedex Priority

Bill To:
Dart Aerospace
1270 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K7

Ship To:
Dart Aerospace
1271 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K8

Qty

3 ✓

Item

JACKING BRACKET, HELICOPTER WEIGHING

Part No.

RBW0805G00332-3G ✓

Received by:

Packaged by:

J.M.L.

Checked by:

AHP

Thank You



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: 042715 ✓

Dated: 4/22/2019

Our Order / Job No: 042715-1AWT

Order Qty: 3 ✓

Part Name: JACKING BRACKET HELICOPTER WEIGHING

Part Number RBW0805G00332-3G ✓

Lot Size: N/A

Ship Date: 4/22/2019

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RBW0805G00332-3G

Rev: 2

Material Size and Type: -1/ 1018 STEEL; -3/ 303SS

Material Specifications: STEEL: ASTM A108; S.S.: A582

Heat Treatment: N/A

Plating/Finish: POWDER COAT YELLOW: FED# 13538

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 03/21/19

Signed: 

DAS
68
9-89

PHGE Machine Works LLC dba Arrow Tech Machine Works
29751 E. Enid Rd. Unit C Eugene, Oregon 97402
Main: (541) 780-6938 | Fax: (458) 215-4938
www.atechmachineworks.com

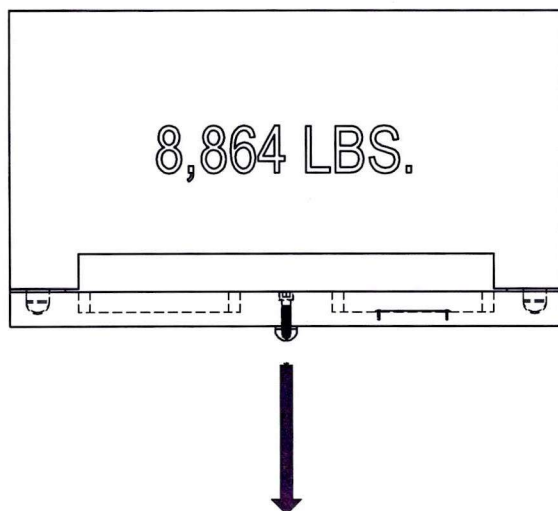
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INSPECTION & TESTING PROCEDURES FOR THE RBW0805G00332-3G, JACKING BRACKET, HELICOPTER WEIGHING. THIS ASSEMBLY IS DESIGNED TO WEIGH THE AW139 HELICOPTER. THIS ASSEMBLY SHOULD BE INSPECTED BEFORE EACH USE.

REPLACE ANY ITEMS THAT ARE DAMAGED OR SUSPECTED OF DAMAGE BEFORE USING!

FIRST ARTICLE WEIGHT TEST

1. AFTER INSPECTION, ATTACH RBW0805G00332-3G AND AN APPROPRIATE TEST WEIGHT OF 8,864 LBS.
2. LET WEIGHT SIT FOR AT LEAST 5 MINUTES, CONTINUALLY CHECKING FOR CRACKS, DEFLECTION, OR DISTORTION.
3. REMOVE WEIGHT AND RE-INSPECT STAND, CHECKING FOR STRESS CRACKS, BENDING, OR DISTORTIONS.



INSPECTOR: *[Signature]*

TESTER: ALAIN PATRY

S.N.: S166620

DATE: 2019/05/02

DAS
19
9-09

DART AEROSPACE	
TITLE JACKING BRACKET, HELICOPTER WEIGHING	
DWG NO. RBW0805G00332-3G	REV 2
MAT'L	UNLESS OTHERWISE SPECIFIED
HEAT	DIMENSIONS ARE IN INCHES
TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH	.XX ± .01 ANGLES ± .5°
SPEC	.X ± .1 SURFACES = 125/
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: GILBERT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: MACKOVJAK	AW139
SCALE 1:8	DATE 12/21/2015 SHEET 5 OF 6